



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4149-5

Job Sheet 184127



DAG
21
9-89

Part No: D4149-5

Job Qty: 40 ea

Part Name: Eyebolt Stud



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B 11.03.03 as per revC DD
verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		11/2/18	0.00	0.00	Start Up Machining-2		
100	Doosan	10 pcs		11/2/18	0.33	2.68	Doosan		
120	QC	10 pcs		11/2/18	0.00	0.00	QC8		
150	Packaging	10 pcs		11/2/18	0.00	0.00	Packaging3-2		
160	QC21-SA	10 Ea		11/2/18	0.00	0.00	QC21		

Part Op
Descriptions: 100 - turn as per dwg and folio FA950

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OCT 2 3 2018

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar 1.00	2.5000 ft (.25 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R1.000	3	35	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Eyebolt Stud	0.250Inches + 0.003 - 0.000	0.253 0.250	Diameter	
2	Eyebolt Stud	1.380Inches ± 0.030	1.410 1.350		
3	Eyebolt Stud	0.400Inches + 0.000 - 0.010	0.400 0.390		
4	Eyebolt Stud	0.700Inches + 0.010 - 0.000	0.710 0.700		
5	Eyebolt Stud	0.030Inches ± 0.010	0.040 0.020	Radius	
6	Eyebolt Stud	0.375Inches + 0.000 - 0.020	0.375 0.355	Diameter	
7	Eyebolt Stud	0.700Inches	0.700	Diameter	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

		+ 0.000 - 0.010	0.690
8	Eyebolt Stud	0.200Inches ± 0.010	0.210 0.190
9	Eyebolt Stud	1.500Inches ± 0.010	1.510 1.490
10	Eyebolt Stud	0.060Inches ± 0.030	0.090 0.030
11	Eyebolt Stud	2.880Inches ± 0.030	2.910 2.850
12	Eyebolt Stud	0.310Inches ± 0.010	0.320 0.300
13	Eyebolt Stud	0.750Inches ± 0.003 - 0.000	0.753 0.750
14	Eyebolt Stud	0.750Inches ± 0.030	0.780 0.720
15	Eyebolt Stud	0.735Inches ± 0.010	0.745 0.725

DAS
 68
 OCT-19-2018

Plex 10/3/18 8:53 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Power ☐ Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐																																																																																																																																					
Date : _____		Step #: _____		DART AEROSPACE Container No: S119814 Part: D4149-5 Job No: 184127 Serial No/Batch: S119814 Instructions: Various STC's Date: 10/19/18 Supervisor: _____ Inspector: _____ Exp Date: _____ Revision: _____ 1270 Ardavan Street Haverhill, MA 01830 TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																																																																																																					
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